

Work Order ID 148785-1

July 08, 2016 10:32:46 AM

148785

Page 1

Item ID: PB67-43001-03

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Blade Fold Assembly

Start Date: 7/8/2016 Start Qty: 3.00

3 SA

Cust Item ID:

Required Date: 8/3/2016 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan:

34

Date:

7/12/16

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

B67-43001-03

Rev C

100

0.00

100

Small Fab

1

AUG 02 2016

DAS
24
9-89

Small Fab

Memo

1.44

Small Fab

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001
page 2. 242 THREADLOCK batch: 134416

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.01

Quality Control

16-03-03

DAS
9
9-89

120

Identify as per dwg & Stock Location:

0.00

120

Packaging

Memo

0.01

Packaging

PPP 148784

DAS
27
9-89

AUG 03 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 148785

July 08, 2016 10:32:46 AM

148785

Page 2

Item ID: PB67-43001-03

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Blade Fold Assembly

Start Date: 7/8/2016 Start Qty: 3.00

Required Date: 8/3/2016 Req'd Qty: 3.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.05							
Quality Control									

DAS
21
9-89

AUG 03 2016

DAS
21
9-89

AUG 03 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER : _____							

Picklist Print

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Page 1

Work Order ID: 148785

148785

Parent Item: PB67-43001-03

PR67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 08-07-30 new issue DD verified by:ec
 IPP Rev:B 08-12-04 up date part list DD Verified by:ec IPP Rev
 C 10.09.24 as per Rev C dwg EC verified by:DD IPP Rev:D 10.10.21
 added NAS1149F0532P DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
240-107 ✓ *240-107* ✓ SPRING SLOTTED PIN		Purchased	No			100	Each	204.0000	8	24		AUG 9 2 2016	DAS 24 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST579		204							
				m132006		36							
				m134651		168							
30345T21 *30345T21* LANYARD		Purchased	No			100	Each	18.0000	1	3			DAS 26 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST570		6							
				M132610		6							
				ST581		12							
				M135014		12							
30345T24 *30345T24* LANYARDS		Purchased	No			100	Each	16.0000	3	9			DAS 26 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST581		16							
				m134499		1							
				m134656		5							
				m134809		10							

JUL 28 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

Picklist Print

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Page 2

Work Order ID: 148785

148785

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

3408A98

Purchased

No

100

Each

35.0000

1

3

3408A98

DETENT BALL SPRING PLUNG

**

DAS
26
9-89LocationLoc QtyLoc Code

ST582

35

123478

35

AN4-10A

Purchased

No

100

Each

158.0000

2

6

AN4-10A

Bolt

**

DAS
26
9-89LocationLoc QtyLoc Code

over003

125

M134762

125

ST345

33

131677

5

M129682

12

M133234

16

AN4-13A

Purchased

No

100

Each

549.0000

1

3

AN4-13A

Bolt

**

DAS
26
9-89LocationLoc QtyLoc Code

FG

20

122808

20

GA

59

m134167

35

m134634

24

over003

100

m134943

100

ST343

370

m134852

370

JUL 28 2016

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Shop Packet Print

Page 2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
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Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			OTHER : ☐																	

Picklist Print

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Page 3

Work Order ID: 148785

148785

Parent Item: PB67-43001-03

PR67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

AN4-15A	Purchased	No		100	Each	346.0000	4	12
---------	-----------	----	--	-----	------	----------	---	----

AN4-15A

Bolt

**

DAS
26
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	26	
120449	26	
over003	320	
m134955	150	
m135127	170	

AN5-26A	Purchased	No		100	Each	35.0000	1	3
---------	-----------	----	--	-----	------	---------	---	---

AN5-26A

Bolt

**

DAS
26
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST337	35	
111424	35	

AN6-11A	Purchased	No		100	Each	23.0000	2	6
---------	-----------	----	--	-----	------	---------	---	---

AN6-11A

BOLT

**

DAS
26
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST335	23	
M132576	23	

AN6-16A	Purchased	No		100	Each	30.0000	2	6
---------	-----------	----	--	-----	------	---------	---	---

AN6-16A

BOLT

**

DAS
26
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST334	30	
m128650	7	
m132576	23	

JUL 28 2016

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Shop Packet Print

Page 3

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WORK ORDER NON-CONFORMANCE / UPDATE



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Past Expiry Date	☐	Manufacturing Process	☐																						
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Picklist Print

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Work Order ID: 148785

148785

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

AN8-13A Purchased No

AN8-13A

Bolt

100 Each 15.0000 2 6

**

DAS
26
9-89

Location Loc Qty Loc Code

ST332 15

M134497 15

BSP43 Purchased No

BSP43

RIVET

100 Each 44.0000 3 9

**

DAS
26
9-89

Location Loc Qty Loc Code

ST558 44

M132703 44

CR3213-4-05 Purchased No

CR3213-4-05

RIVET

100 Each 215.0000 1 3

**

DAS
26
9-89

Location Loc Qty Loc Code

CCK003 100

m135056 100

CCK005 100

m135135 100

ST319 15

m134852 15

D3440-1 Manufactured No

D3440-1

Tube Guide (Supersedes B67-43001-25/-307)

100 Each 6.0000 1 3

**

Location Loc Qty Loc Code

Mezz2 6

142150 6

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Page 5

Work Order ID: 148785

148785

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

D3440-3 Manufactured No

100 Each

6.0000

1

3

AUG 02 2016

DAS
24
9-89

D3440-3

Clamp (Supersedes B67-43001-309)

**

Location

Loc Qty

Loc Code

Mezz2

6

142151

6

D3444-1

Manufactured No

100 Each

4.0000

1

3

AUG 02 2016

DAS
24
9-89

D3444-1

Velcro Loop Belt

**

Location

Loc Qty

Loc Code

Mezz2

4

133002

4

D3447-9

Manufactured No

100 Each

3.0000

2

6

AUG 02 2016

D3447-9

Swing Arm

**

Location

Loc Qty

Loc Code

Mezz2

3

142213

3

D3449-1

Manufactured No

100 Each

6.0000

1

3

AUG 02 2016

D3449-1

Pad

**

Location

Loc Qty

Loc Code

Mezz2

6

133652

6

D3451-043

Manufactured No

100 Each

1.0000

1

3

AUG 02 2016

DAS
24
9-89

D3451-043

Handle And Lock-Down Assembly

**

Location

Loc Qty

Loc Code

Mezz2

1

142169

1

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Shop Packet Print

Page 5

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____	
Misidentified ☐	Past Due ☐																																																														

Picklist Print

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Page 6

Work Order ID: 148785

148785

Parent Item: PB67-43001-03

PR67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

D3451-045

Manufactured No

100

Each

1.0000

1

3

DAS

24

AUG 02 2016

D3451-045

Handle And Lock-Down Assembly

**

\$148786 → 2

Location

Loc Qty

Loc Code

Mezz2

1

142170

1

D3922-1

Manufactured No

100

Each

36.0000

1

3

**

D3922-1

Clip

Location

Loc Qty

Loc Code

ST059

36

111733

11

148014

25

MS17984-C408

Purchased No

100

Each

8.0000

1

3

**

MS17984-C408

PIN, QUICK RELEASE

DAS

22

9-89

C410

16.05.16

Location

Loc Qty

Loc Code

ST315

8

m132576

8

MS17984-C418

Purchased No

100

Each

19.0000

3

9

**

MS17984-C418

QUICK RELEASE PIN

Location

Loc Qty

Loc Code

FG

1

123482

1

over005

10

147087

10

ST315

8

m134676

8

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Page 6

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														

Picklist Print

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Work Order ID: 148785

148785

Parent Item: PB67-43001-03

PR67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

MS21042L4

Purchased

No

100

Each

2,587.000

9

27

MS21042I 4

Locknut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	51	
m133363	51	
GA	156	
m133769	156	
OVER007	1000	
m135127	1000	
ST3003	500	
m134955	500	
ST303	786	
m127376	12	
m134861	274	
m135058	500	
ST305	94	
m130922	94	

DAS
6
9-89

27

MS21042L5

Purchased

No

100

Each

487.0000

1

3

MS21042I 5

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	81	
m127813	81	
ST303	406	
m134055	6	
m134509	100	
m134762	50	
m134955	150	
m135058	100	

DAS
6
9-89

JUL 28 2016

3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														

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Work Order ID: 148785

148785

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

MS21042L6 Purchased No 100 Each 221.0000 4 12

MS21042L6

Nut

**

DAS
6
9-89

Location	Loc Qty	Loc Code
ST303	221	
m133938	6	
m134055	5	
m134676	50	
m134955	100	
m135058	60	

MS24694-S109 Purchased No 100 Each 60.0000 2 6

MS24694-S109

Screw, Flat Head

**

134514

DAS
6
9-89

Location	Loc Qty	Loc Code
Mezz	24	
115708	24	
ST282	36	
M132576	36	

MS27039-1-07 Purchased No 100 Each 345.0000 1 3

MS27039-1-07

Screw

**

DAS
6
9-89

Location	Loc Qty	Loc Code
GA	270	
125654	270	
Return2016	1	
m127813	1	
ST281	74	
m135015	74	

3

4.11.2016



DART
AEROSPACE

Work Order update only ☐

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev I

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Work Order ID: 148785

148785

Parent Item: PB67-43001-03

PR67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

MS27039-1-23

Purchased

No

100

Each

53.0000

1

3

MS27039-1-23

SCREW

**

124326

DAS

6

9-89

Location

Loc Qty

Loc Code

ST279

53

18057

3

m135043

50

MS51859-6

Purchased

No

100

Each

60.0000

8

24

MS51859-6

WASHER

**

DAS

6

9-89

Location

Loc Qty

Loc Code

st268

60

m134502

60

MS51859-7

Purchased

No

100

Each

121.0000

2

6

MS51859-7

Washer

**

DAS

6

9-89

Location

Loc Qty

Loc Code

st268

121

M132576

21

M135058

100

MS51859-8

Purchased

No

100

Each

276.0000

8

24

MS51859-8

Washer

**

DAS

6

9-89

Location

Loc Qty

Loc Code

st268

276

m134606

276

JUL 28 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
										QC / QA Coordinator Approval															
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

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Work Order ID: 148785

148785

Parent Item: PB67-43001-03

PR67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

NAS1149DN632J Purchased No

100 Each 593.0000 4 12

NAS1149DN632J

Washer

**

DAS

6

9-89

Location

Loc Qty

Loc Code

ST265

593

m134370

593

NAS1149F0316P Purchased No

100 Each 143.0000 1 3

NAS1149F0316P

WASHER

**

DAS

6

9-89

Location

Loc Qty

Loc Code

ST262

143

M132579

143

NAS1149F0432P Purchased No

100 Each 1,515.000 16 48

NAS1149F0432P

WASHER

**

DAS

6

9-89

Location

Loc Qty

Loc Code

ST260a

1000

M134955

1000

ST262

515

M134502

515

NAS1149F0532P Purchased No

100 Each 2,436.000 2 6

NAS1149F0532P

Washer

**

DAS

6

9-89

Location

Loc Qty

Loc Code

ST260a

600

m133725

600

ST262

1836

18057

1836

JUL 28 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐									

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Work Order ID: 148785

148785

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

NAS1149F0632P

Purchased

No

100

Each

175.0000

8

24

NAS1149F0632P

WASHER

**

DAS
6

Location

Loc Qty

Loc Code

ST262

175

18057

4

m134497

171

NAS1149F0832P

Purchased

No

100

Each

123.0000

2

6

NAS1149F0832P

WASHER

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST262

123

18057

123

NAS43DD3-61

Purchased

No

100

Each

13.0000

1

3

NAS43DD3-61

Spacer

**

DAS
6
JUL 28 2016

Location

Loc Qty

Loc Code

ST550

13

m128635

13

PB67-43001-09

Manufactured

No

100

Each

0.0000

1

3

PB67-43001-09

Aft Blade Fold Assembly Weldment

**

3148789 → 3

DAS
6
JUL 28 2016

PB67-43001-13

Manufactured

No

100

Each

0.0000

1

3

PB67-43001-13

Aft Adjustable Blade Support Assembly

**

3148803 → 3

DAS
6
JUL 28 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

July 08, 2016 10:32:45 AM

Page 12

Work Order ID: 148785

148785

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

PB67-43001-135

Manufactured No

100 Each

6.0000

1 3

PB67-43001-135

Male Eye

**

AUG 9 2 2016

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

6

139212

6

PB67-43001-137

Manufactured No

100 Each

6.0000

1 3

PB67-43001-137

Locking Sleeve

**

Location

Loc Qty

Loc Code

Mezz2

6

100004

1

133704

1

139213

4

PB67-43001-155

Manufactured No

100 Each

15.0000

1 3

PB67-43001-155

Pin

**

Location

Loc Qty

Loc Code

Mezz2

15

133705

3

142807

12

PB67-43001-17

Manufactured No

100 Each

0.0000

1 3

PB67-43001-17

Aft Adjustable Blade Support Assembly

**

3148824 → 3

AUG 9 2 2016
DAS
24
9-89

PB67-43001-21

Manufactured No

100 Each

4.0000

1 3

PB67-43001-21

Upper Blade Support And Cover Assembly

**

3148824 → 3

Location

Loc Qty

Loc Code

Mezz2

4

142800

4

July 08, 2016 10:32:45 AM

Shop Packet Print

Page 12

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By			
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : _____											

Picklist Print

July 08, 2016 10:32:45 AM

Work Order ID: 148785

148785

Parent Item: PB67-43001-03

PR67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

PB67-43001-23 Manufactured No

100 Each

6.0000 1 3

PR67-43001-23

Lower Blade Support And Cover Assembly

**

3 C

Location

Loc Qty

Loc Code

Mezz2

6

142801

6

PB67-43001-261

Manufactured No

100 Each

7.0000 2 6

PR67-43001-261

Lever Arm

**

DAS 24 9-gc

AUG 02 2016

Location

Loc Qty

Loc Code

Mezz2

7

139215

7

PB67-43001-265

Manufactured No

100 Each

29.0000 5 15

PR67-43001-265

Deltin Bushing

**

15 C

Location

Loc Qty

Loc Code

Mezz2

29

139214

29

PB67-43001-299

Manufactured No

100 Each

17.0000 2 6

PR67-43001-299

Bushing

**

6 C

Location

Loc Qty

Loc Code

Mezz2

17

139216

17

PB67-43001-305

Manufactured No

100 Each

2.0000 1 3

PR67-43001-305

Bearing

**

3 C

Location

Loc Qty

Loc Code

Mezz2

2

133706

2

2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

July 08, 2016 10:32:45 AM

Page 14

Work Order ID: 148785

148785

Parent Item: PB67-43001-03

PR67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

PB67-43001-37

Manufactured No

100 Each

4.0000 1 3

PR67-43001-37

Tube Arm Assembly

**

3

Location

Loc Qty

Loc Code

Mezz2

4

140779

1

142797

3

PB67-43001-57

Manufactured No

100 Each

3.0000 1 3

PR67-43001-57

Stabilizer Arm

**

3

Location

Loc Qty

Loc Code

Mezz2

3

142796

3

PB67-43001-59

Manufactured No

100 Each

3.0000 1 3

PR67-43001-59

Adjustable Attachment Arm

**

3

Location

Loc Qty

Loc Code

Mezz2

3

142794

3

PB67-43001-63

Manufactured No

100 Each

1.0000 1 3

PR67-43001-63

Handle Assy

**

1

DAS
24
9-80

AUG 02 2016

Location

Loc Qty

Loc Code

Mezz2

1

143784

1

Missing 2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

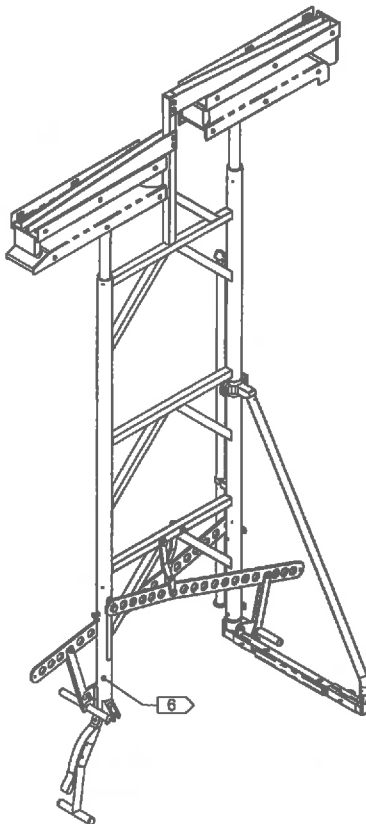
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER :							

ITEM	QTY -03	P/N	DESCRIPTION
	X	B67-43001-03	AFT BLADE FOLD ASSY
1	1	B67-43001-09	AFT BLADE FOLD ASSY WELDMENT
2	1	B67-43001-13	AFT ADJUSTABLE BLADE SUPPORT ASSY
3	1	B67-43001-17	AFT ADJUSTABLE BLADE SUPPORT ASSY
4	1	B67-43001-21	UPPER BLADE SUPPORT AND COVER ASSY
5	1	B67-43001-23	LOWER BLADE SUPPORT AND COVER ASSY
6	1	B67-43001-37	TUBE ARM ASSEMBLY
7	1	B67-43001-57	STABILIZER ARM
8	1	B67-43001-59	ADJUSTABLE ATTACHMENT ARM
9	1	B67-43001-63	SHORT T-HANDLE ASSEMBLY
10	1	B67-43001-135	MALE EYE
11	1	B67-43001-137	LOCKING SLEEVE
12	1	B67-43001-155	PIN
13	2	B67-43001-261	LEVER ARM
14	5	B67-43001-265	DELRIIN BUSHING
15	2	B67-43001-298	BUSHING
16	1	B67-43001-305	BEARING
17	1	D3440-1	TUBE GUIDE
18	1	D3440-3	CLAMP
19	1	D3444-1	VELCRO LOOP BELT
20	2	D3447-9	SWING ARM
21	1	D3449-1	PAD
22	1	D3451-043	HANDLE & LOCK-DOWN ASSY
23	1	D3451-045	HANDLE & LOCK-DOWN ASSY
24	1	D3922-1	CLIP
25	1	30345T21	LANYARD
26	3	30345T24	LANYARD
27	1	3408A98	DETENT BALL PLUNGER
29	2	AN4-10A	BOLT
30	1	AN4-13A	BOLT
31	4	AN4-15A	BOLT
32	1	AN5-28A	BOLT
33	2	AN6-11A	BOLT
34	2	AN6-18A	BOLT
35	2	AN8-13A	BOLT
36	3	BSP43	RIVET
37	1	CR3213-4-05	RIVET
38	8	MS171534	SPRING SLOTTED TENSION PIN (OR 240-107)
39	1	MS17984-C408	QUICK RELEASE PIN
40	3	MS17984-C418	QUICK RELEASE PIN
41	9	MS21042L4	NUT
42	1	MS21042L5	NUT
43	4	MS21042L6	NUT
44	2	MS24694-S109	SCREW
45	1	MS27039-1-07	SCREW
46	1	MS27039-1-23	SCREW
47	8	MS51859-6	NYLON WASHER
48	2	MS51859-7	NYLON WASHER
49	8	MS51859-8	NYLON WASHER

ITEM	QTY -03	P/N	DESCRIPTION
	X	B67-43001-03	AFT BLADE FOLD ASSY
50	1	NAS43DD3-61	SPACER
51	4	NAS1149DN632J	WASHER
52	1	NAS1149F0318P	WASHER
53	16	NAS1149F0432P	WASHER
54	2	NAS1149F0532P	WASHER
55	8	NAS1149F0632P	WASHER
56	2	NAS1149F0832P	WASHER



B67-43001-03 AFT BLADE FOLD ASSY

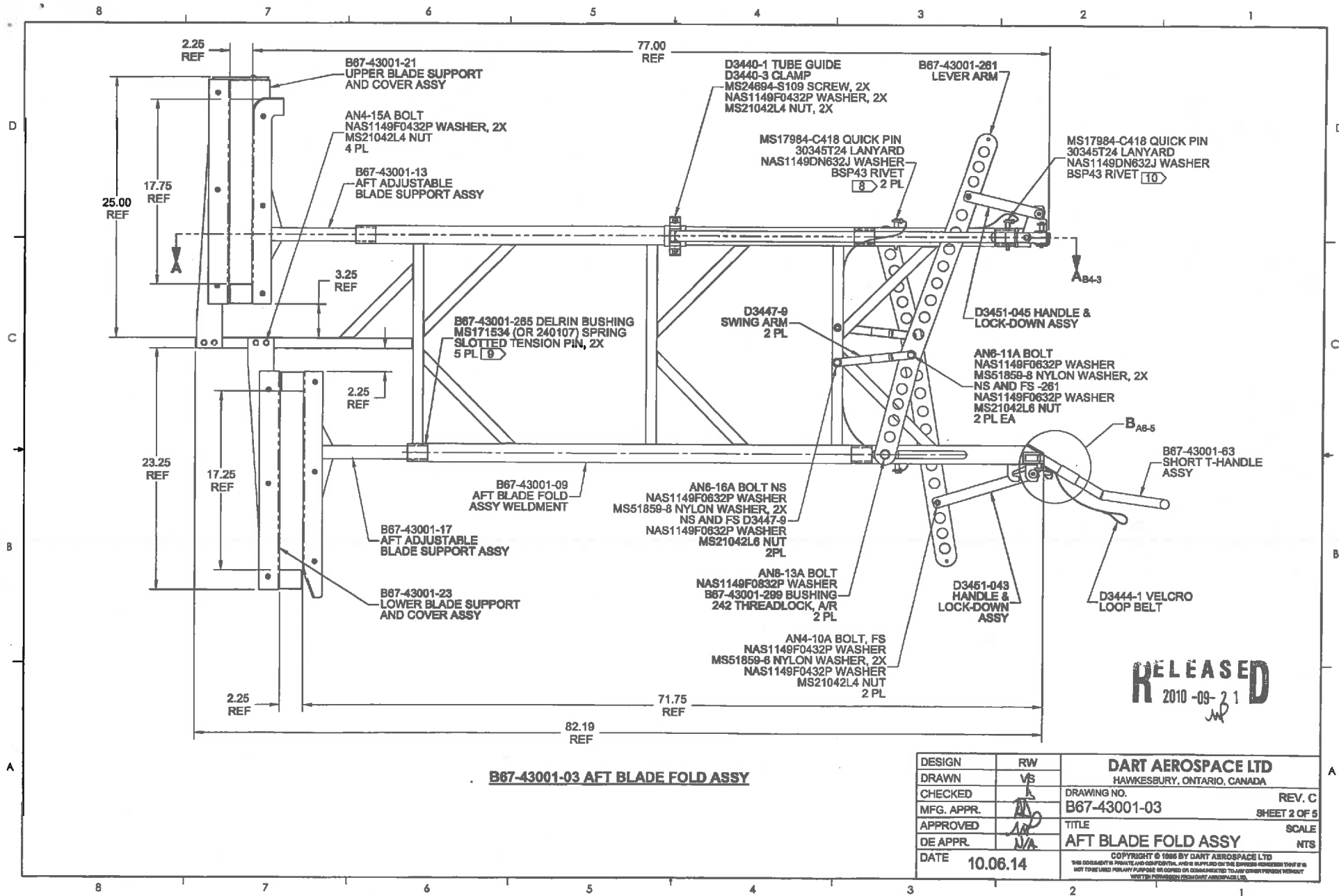
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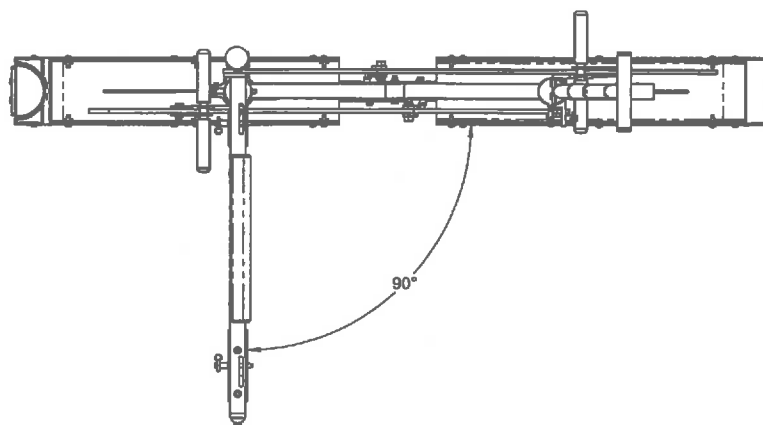
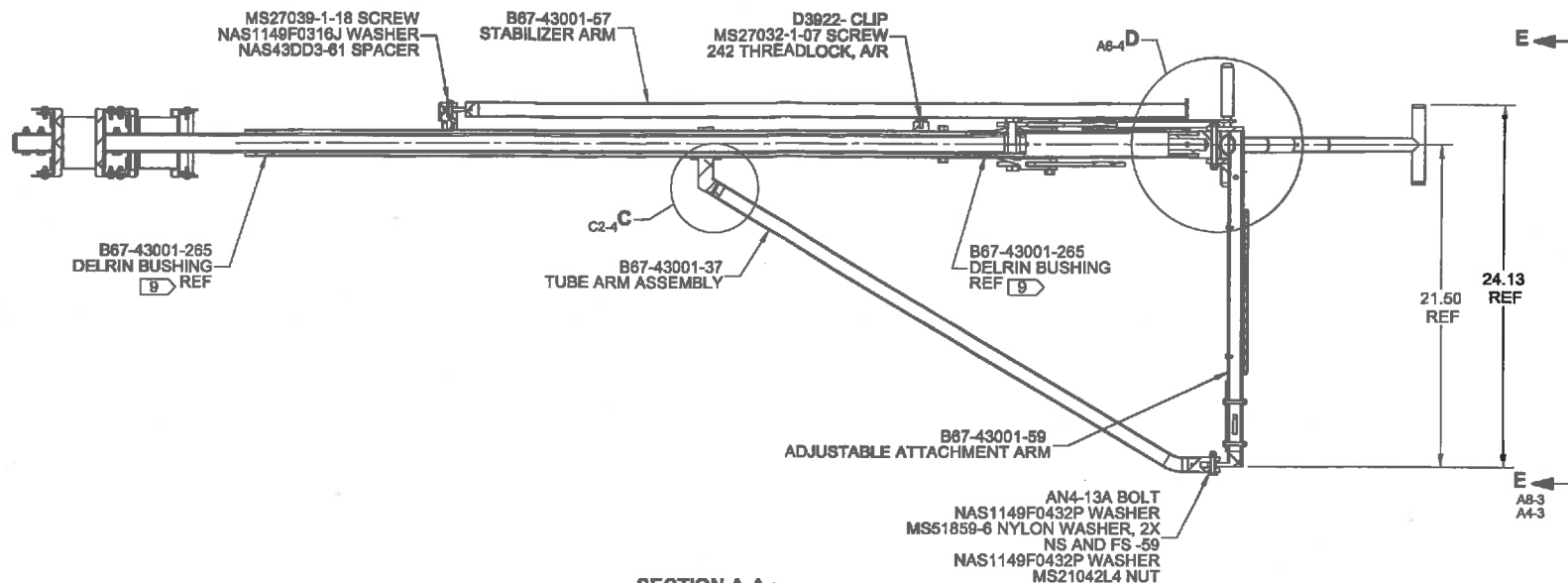
- 1) MATERIAL: NONE
- 2) FINISH: TOUCH UP PAINT WITH SANDFLEX GREEN.
POSSIBLE SUPPLIER BERTRAND BODY SHOP SUPPLIES
P/N DART01K
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH RED LABEL
- 7) WEIGHT: 60.57 lbs
- 8) WITH THE INNER TUBE CRADLE ASSEMBLY LOCKED IN ITS LOWEST MOST RECESSED POSITION, TRANSFER DRILL $\phi 0.250$ DIA HOLE FROM THE OUTER TUBE TO THE INNER TUBE AND THRU THE OUTER TUBE. DEBURR, REMOVE DEBRIS, AND TOUCH UP PAINT PER ITEM 2 AS REQUIRED. 2 PL.
- 9) INSTALL TEFLON BUSHING -265 INSIDE THE OUTER TUBE. MATCH DRILL BUSHING TO EXISTING HOLES IN OUTER TUBE USING 1/8" DIAMETER DRILL. INSERT MS171534 (OR 240170) SPRING SLOTTED PIN AND GRIND FLUSH WITH CONTOUR OF OUTER TUBE. 10 PL (2 PL PER BUSHING)
- 10) DRILL $\phi 0.250$ DIA HOLE THRU -09/-265/-305 WITH -37 AT VERTICAL FULL OPEN POSITION. DRILL ADDITIONAL HOLE WITH -37 AT FULL CLOSED POSITION, ASSURING -37 CLEARS ADJACENT STRUCTURE.
- 12) DRILL A $\phi 0.128$ DIA HOLE THRU -343 (COMPONENT OF -37) AND -26 (COMPONENT OF -09 ASSY). INSERT MS171534 (OR 240170) SPRING SLOTTED PIN, AND GRIND FLUSH WITH -37.
- 13) INSERT -135 INTO -243 TUBE (COMPONENT OF -09 ASSY) ALIGN HOLES, ASSURING ORIENTATION SHOWN. INSERT 3408A98 DETENT BALL, ASSURING BALL PROTRUDES SLIGHTLY ABOVE OUTER SURFACE OF -243 TUBE. LOCATE AND INSTALL AN MS171534 (OR 240170) SPRING SLOTTED PIN BY DRILLING A $\phi 0.128$ DIA HOLE THRU -243 AND -135. ENSURE -137 SLEEVE SLIDES FREELY OVER HINGE AND LOCKS INTO DETENT.
- 14) BOND D3449-1 TO B67-43001-09 USING CONTACT CEMENT AS PER MANUFACTURER'S SPECIFICATION.

RELEASED
2010-09-21

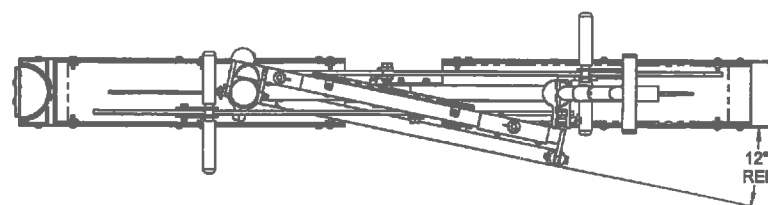
54 148785 7/12/16

C		REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 3 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR08-011.		VS	10.06.14
REV.	DESCRIPTION			BY	DATE
DESIGN	RW	DART AEROSPACE LTD			
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO.	REV. C		
MFG. APPR.		B67-43001-03	SHEET 1 OF 6		
APPROVED		TITLE	SCALE		
DE APPR.	VA	AFT BLADE FOLD ASSY	NTS		
DATE	10.06.14		COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.		





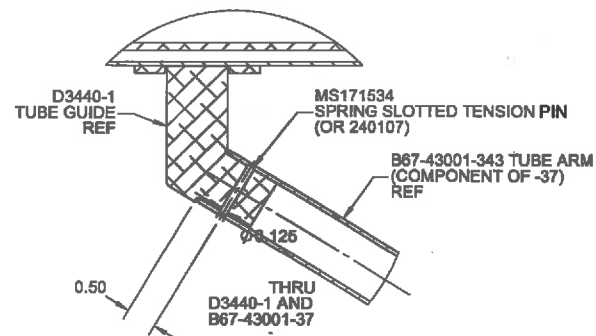
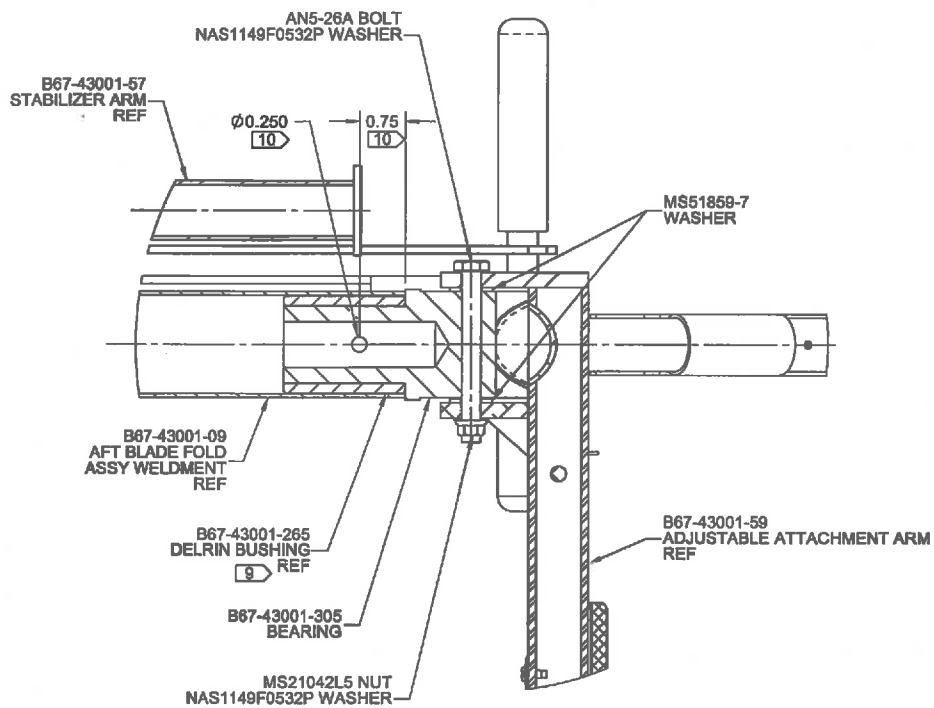
C1-3 VIEW E-E: VERTICAL FULL OPEN OR "IN USE" POSITION [10]



C1-3 VIEW E-E: FULL CLOSED OR "STORAGE" POSITION [10]

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2010-08-21

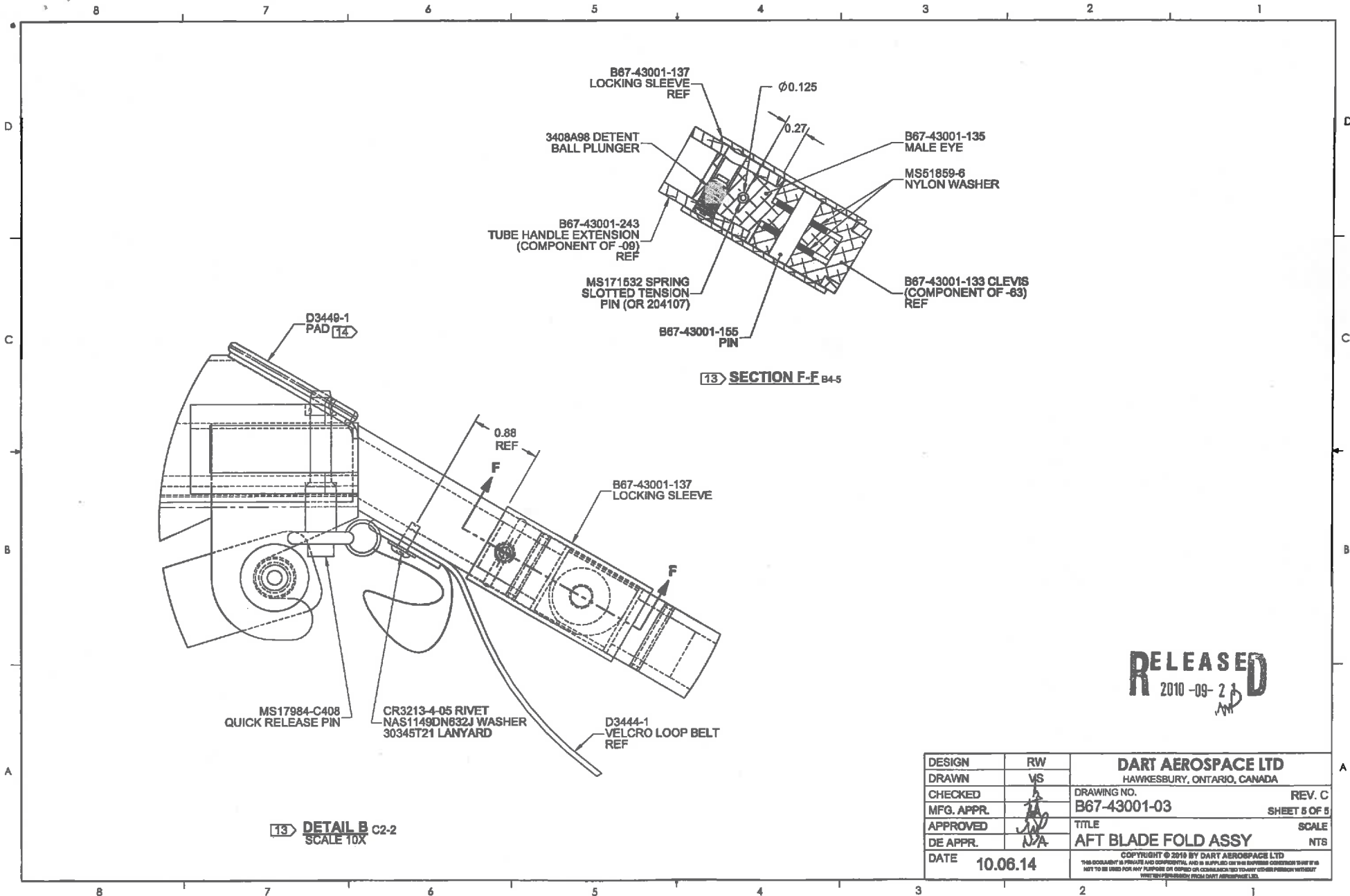
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-03	SHEET 3 OF 5
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DE APPR.	N/A	AFT BLADE FOLD ASSY	NTS
DATE	10.06.14	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-03	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT BLADE FOLD ASSY	NTS
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2010-09-23

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-03	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT BLADE FOLD ASSY	NTS
DATE	10.06.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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